

Split

Work Order ID 58287-1

May 3, 2010 10:25:04 AM



Page 1

Item ID: D2565-101

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00

Required Date: 5/05/10

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date: 10-5-02

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100



Brake NC

Brake NC

NC BRAKE

Memo

Punch as per Dwg D2565 using DT 8313

0.00

0.00

SA 10/05/12

10

110



Small Fab

Small Fab

Small Fab

Memo

Drill hole open to .316 O as per Dwg D2565 (one end only)

Deburr and

0.00

0.00

SA 10/05/12

+3

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SA 10/05/12









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Required Date: 5/05/10

Reference:

Start Qty: 10.00

Req'd Qty: 10.00

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

M114207

Memo

START TIME:

1:15pm

FINISH TIME:

12:45pm

Set Up/  
Run Hours

0.00

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

⇒ JH 10/05/17

3 0

OVEN TEMPERATURE:

400°F

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3 10 5-17.

150



Packaging

Packaging

Identify as per dwg & Stock Location:

270

0.00

Memo

0.00

PC 10/05/17 (3)







# Work Order ID 58287

May 3, 2010 10:25:05 AM

Page 3

Item ID: D2565-101

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Required Date: 5/05/10

Reference:

Start Qty: 10.00

Req'd Qty: 10.00

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

10/05/17

PM 10-5-17  
(3)





# Checklist Print

May 3, 2010 10:25:03 AM

Work Order ID: 58287

Parent Item: D2565-101

Parent Item Name: Strut

Comments: IPP: F 02.04.16 Added dwg Rev.C1 NG

Start Date: 5/03/10

Required Date: 5/05/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	303.4562	1.71			
304 RD Tube .750 x .049W												

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	275.5927	
108498	0	
114482	275.5927	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

2/19 SA 06/05/12







**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**

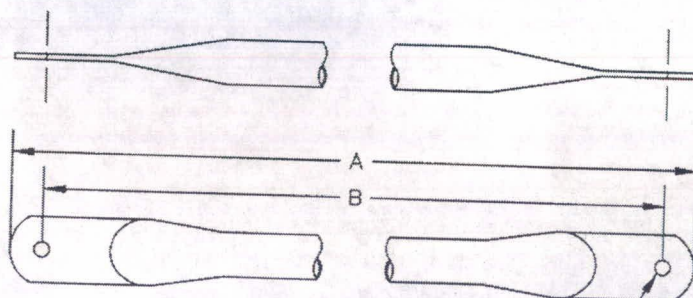
04.05.05

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 58287

B/ 10-5-03



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

**GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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